

Date: Wednesday, 5/23/2007 3:45:34 PM
 Set: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CHAFING SHIELD		
Job Number	: 32513		Part Number	: D31891		
Estimate Number	: 10840		Drawing Number	: D3189 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 5/23/2007 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 5/30/2007 Qty: 12 Um: Each		
Previous Run	: 31147					
Written By	: <i>10</i>					
Checked & Approved By	: <i>MF 07-05-24</i>					
Comment	: Est. B 05-08-22 No longer made in-house KJ/JLM Est Rev:C 06-03-24 Rolling Now made in House JLM Est Rev:D 07-04-16 As per Rev B JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S26GA	304/316 0.018 SHEET <i>MF 07-05-29</i>
2.0	SHEAR	SHEAR <i>MF 07-05-29</i>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 <i>MF 07-05-30</i>
4.0	QC5	INSPECT WORK TO CURRENT STEP <i>SB 07/05/130</i> (12)
5.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>MF 07-05-30</i> (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:45:34 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CHAFING SHIELD

Job Number: 32513

Part Number: D31891

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

07/05/31

Job Completion



07/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

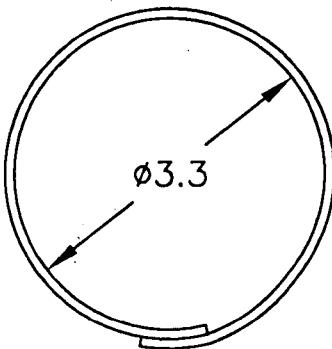
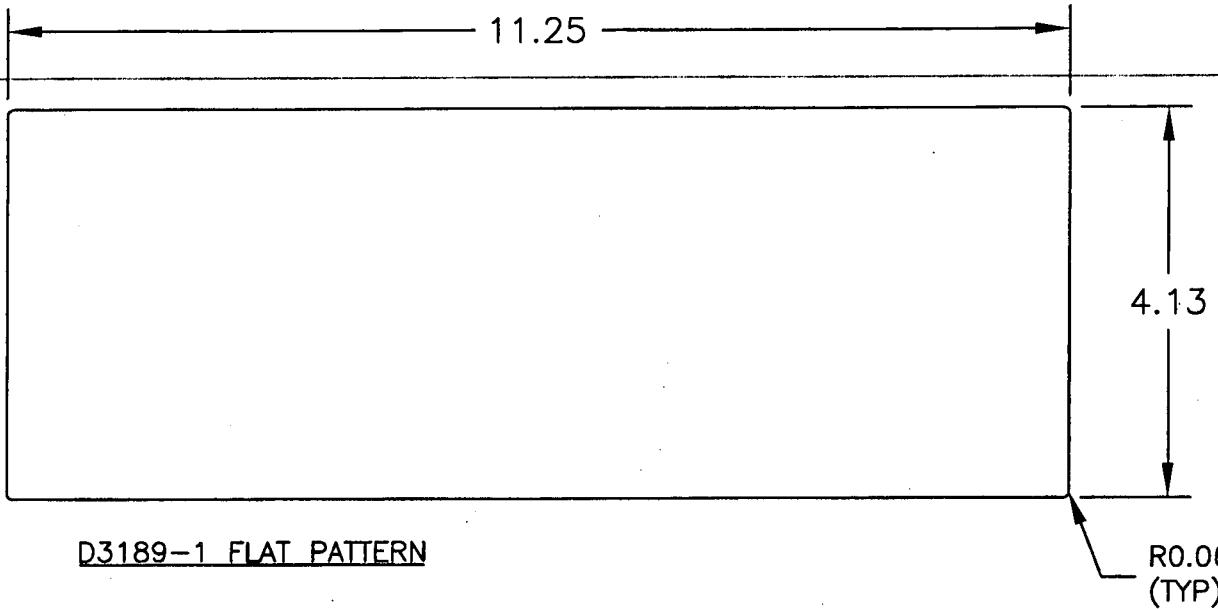
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	9P	DRAWN BY	9P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	11	APPROVED	11	DRAWING NO. D3189 REV. B SHEET 1 OF 2
DATE	07.01.05			TITLE CHAFING SHIELD SCALE 1:2
A	03.05.08			
B	07.01.05			ADD -3

RELEASED

07.03.27 ~~11~~

D3189-1 ROLLING DETAIL
NOT TO SCALE

D3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
32513

NO.

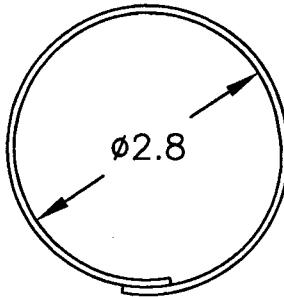
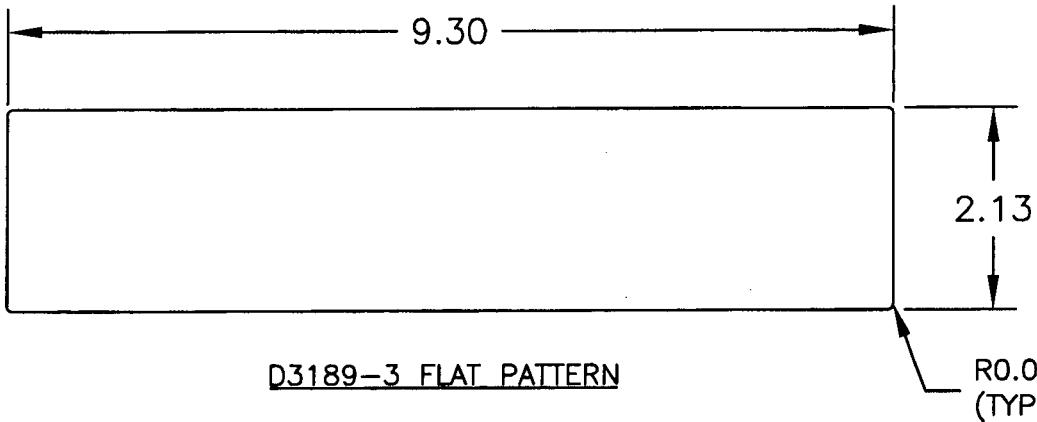
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DART

DESIGN	9P	DRAWN BY	9P	DART AEROSPACE LTD	
CHECKED	11	APPROVED	11	DRAWING NO.	REV. B
				D3189	SHEET 2 OF 2
DATE				TITLE	SCALE
	07.01.05			CHAFING SHIELD	1:2

RELEASED

07.03.27 ~~11~~

D3189-3 ROLLING DETAIL
NOT TO SCALE

D3189-3 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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